

Work Order ID: 55342

January 13, 2010 10:27:33 AM

Page 1

Item ID: D3722-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Spacer Wedge

Start Date: 1/13/10 Start Qty: 10.00

Cust Item ID:

Required Date: 1/20/10 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan: RLDate: 10-1-13

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3722

Rev A

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3722 ☐ Dwg Rev: A ☐ Prog Rev: A ☐ 2-  
Deburr if necessary

6061 .125

Deburr =&gt; m-k 10/01/26

40X

40

RB 10-1-13

110

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

RB 10-1-13

120

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

2) Scuba 26

located  
x40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Page 2

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Customer:

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Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
	Small Fab								
Small Fab	Memo	0.00							
Small Fab	1-grind to fit profile of D3188-3 as per dwg D3722-2-Deburr if necessary.								
140		0.00							
	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									
150		0.00							
	Chemical Conversion Coat per QSI005 4.1								
HandFinish	Memo	0.00							
Hand Finishing									

*N/A - grind to fit with spacer body*  
*W*

*28*

W/O:		WORK ORDER CHANGES					
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Item ID: D3722-1

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Setup Start



Revision ID:

Stop



Item Name: Spacer Wedge

Start Date: 1/13/10 Start Qty: 10.00



Cust Item ID:

Required Date: 1/20/10 Req'd Qty: 10.00

Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00							
170  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum  Memo START TIME: _____ <input type="checkbox"/> OVEN TEMPERATURE: _____ _____ FINISH TIME: _____	0.00  0.00							
180  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Work Order ID 55342

January 13, 2010 10:27:34 AM



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Item ID: D3722-1

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Setup Start



Revision ID:

Stop



Item Name: Spacer Wedge

Start Date: 1/13/10 Start Qty: 10.00



Cust Item ID:

Required Date: 1/20/10 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190



Packaging

Packaging

Identify as per dwg & Stock Location: ST 50

0.00

Memo

0.00

*Stk 25 is u*

*4/13/10 (40)*

200



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

*11/3/10 AG*

*u 11.03.09*

W/O:		WORK ORDER CHANGES					
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# Picklist Print

Page 1

January 13, 2010 10:27:40 AM

Work Order ID: 55342



Parent Item: D3722-1



Parent Item Name: Spacer Wedge

Start Date: 1/13/10

Required Date: 1/20/10

Comments: IPP Rev:A New Issue 08-01-28 DD verified by: EC

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.125 		Purchased	No			100	sf	229.8823	0.7179	3.		
6061-T6.125 Sheet											B10-1-13	

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	229.8823	
110062	1.85	
111642	19.592	
112476	32	
112567	18.7403	
113424	61.7	
113608	96	

113424  
 40

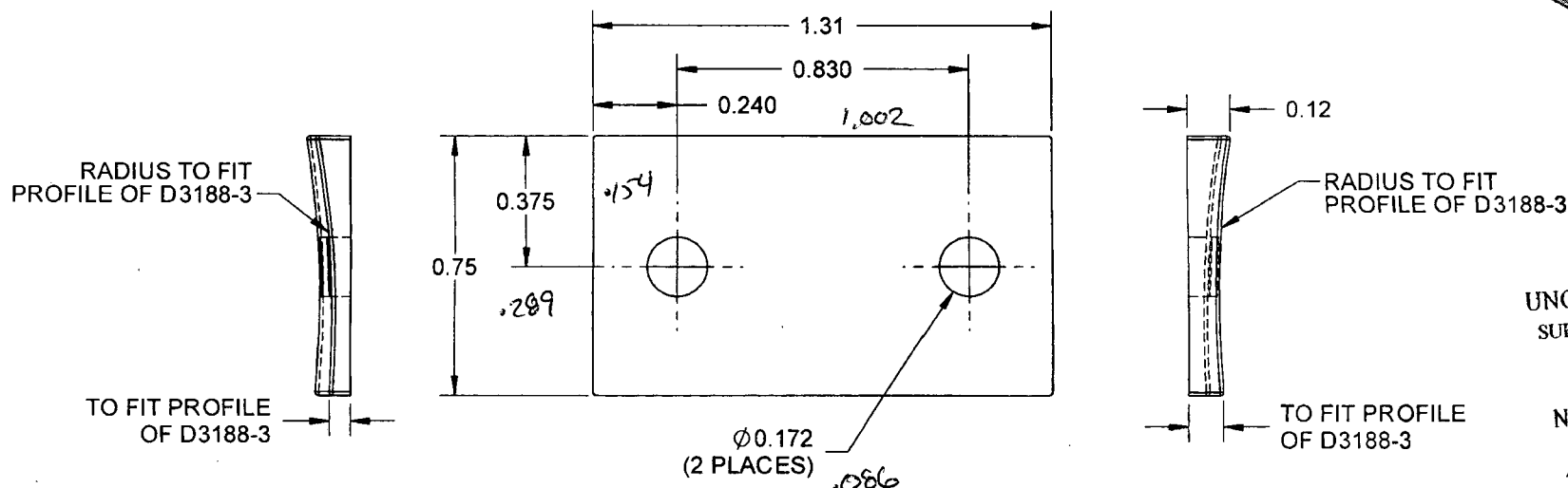
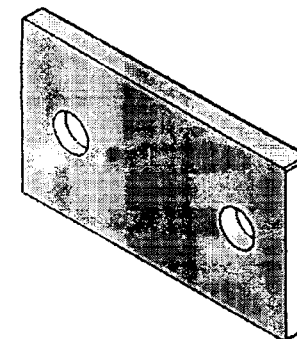
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SHOP COPY  
RETURN TO  
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 55342  
PP 104-B

# **D3722-1 SPACER WEDGE**

RELEASED  
04.01.07

## **NOTES:**

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR PER AMS QQ-A-225/8 OR AMS 4117/4128/4115/4116 OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B) OR 6061-T6 (OR T62) ALUMINUM SHEET 0.125 THICK PER QQ-A-250/11 OR AMS 4025 OR 4027 (REF DART SPEC M6061T6S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3722-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.01 lbs

A	NEW ISSUE	LE	07.12.21
REV.	DESCRIPTION	BY	DATE
DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	LE		
CHECKED	RA	DRAWING NO.	REV. A
MFG. APPR.	RA	D3722	SHEET 1 OF 1
APPROVED	RA	TITLE	SCALE
DE APPR.	RA	SPACER WEDGE	2:1
DATE	07.12.21	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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